

M40
5228990

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6101-005
Job Sheet 202189



Part No: D6101-005

Job Qty: 20 pcs

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/19

Job Tracking No:

Due Date: 11/13/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	20 pcs	11/13/19	11/13/19	0.00	0.00	Purchasing - 1		NOV 01 2019
							Purchasing - 2	DAS 81	
							Purchasing - 3	9-89	
110	Packaging 2-1 - Receive - B4B	20 pcs	11/13/19	11/13/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B	DAS 81	
							Packaging 2 - 15 - B4B	9-89	
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		



Container No: S228990



Part: D6101-005

Job No: 202189

Serial No/Batch: S228990

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/01/19

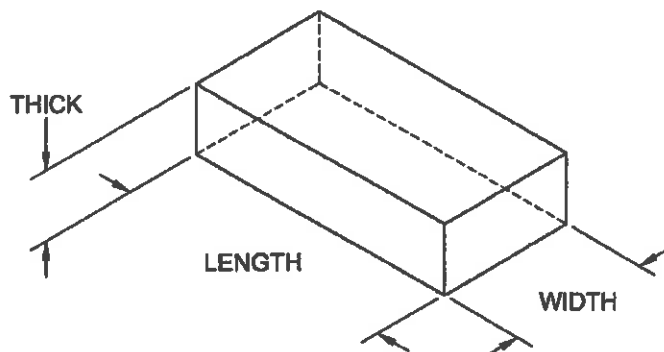
Plex 10/22/19 9:24 AM Dart.Lavoie.Chantal

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120	QC 18	20 pcs	11/13/19	0.00 0.00	QC 18 - 12
					QC 18 - 14
					QC 18 - 22
					QC 18 - 25
					QC 18 - 48
					QC 18 - 58
					QC 18 - 61
					QC 18 - 9
					QC 18 - 81
130	Packaging 3-1 - Stock - B4B	20 pcs	11/13/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B

DAS
81
9-89

NOV 01 2019

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/WP

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044870



Supplier: MEC002-VU
Metaux Castles
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044870

PO Date: 10/23/19

Due Date: 11/19/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

OCT 24 2019

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	202188	D6101-003P	D6101	72742	7075-T7351 2X6.25X7.875 Various STC's AS PER DWG D6101 REV. B SIZE: 7.875" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 7.875" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	11/19/19	20 pcs	0 pcs	20 pcs	\$38.82/pcs	\$776.40

OCT 31 2019



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044870



Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
2	202189	D6101-005P	D6102	72744	7075-T7351 8.25X5.0X2.5 : Various STC's AS PER DWG.D6101 REV.B SIZE: 5.00" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG 5.00" LENGHT MATERIAL: 7075-T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	11/19/19	20 pcs	0 pcs 20 pcs Vm	20 pcs	\$40.54/pcs	\$810.80
												OCT 31 2019	
3	202190	D6103-003P	D6104		Round Alum Billet : Various STC's AS PER DWG D6103 REV. B MATERIAL: 7075-T7351 AS PER QQ- A-225/9 SIZE: 3.500" X 12.500" LONG	Firmed	-	11/19/19	12 pcs	0 pcs 10 pcs Vm	12 pcs	\$60.40/pcs	\$724.80
												OCT 31 2019	
Grand Total:												\$2,312.00	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries. (DFARS)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/23/19 2:36 PM Dart.Lavoie.Chantal



Castle Metals®

A. M. Castle & Co.

**PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

Page 1 of 2

Shipment No:4028263

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN	Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA
Date Shipped	Inco Terms	Freight Terms	Carrier	BOL No
30-OCT-19	FCA HAWKESBURY ON CAN	Prepay & Add	LOCAL_FLEET	4028263-6

Shipment Details	Final Destination Branch - TOR
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Order No	Line No	Item No	Description
5638999	2	72744	2.5000.PL.7075.T7351.ALUMINUM.GRAIN TO RUN ALONG 5.0000 IN.8.2500.5.0000 SPECIFICATIONS: AMS-QQ-A-250/12
Purchase Order No	Part Number	Ordered Qty	Invoice Qty
POHB044870	YOUR ITEM NUMBER: D6101-005	20.00 PCS	20.00 PCS
Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS		

Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
122957247	KAISER ALUMINUM			20	5.0000	8.2500	213.3120

These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. Government or as otherwise authorized by U.S. law and regulations.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Date Printed: 30-OCT-2019 03:50:31 PM



Castle Metals®

A. M. Castle & Co.

**PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

Page 2 of 2

Reviewed by Authorized Castle Metals Representative:	OCT 30 2019	Date:	Name: <i>[Signature]</i>
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SHIP TO:

A M CASTLE & CO
3050 SOUTH HYDRAULIC
WICHITA, KS 67216

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

KAISER ALUMINUM

Trentwood Works

PO Box 15108, Spokane Valley WA 99215-5108

15000 E Euclid, Spokane Valley WA 99216

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4552523

CUSTOMER PO NUMBER: 484310-1	WORK PACKAGE:	CUSTOMER PART NUMBER: 752241	SHIP RUN/LOAD: 104547/8	GOVT CONTRACT NUMBER:
KAISER ORDER NO: 1273514-1	SHIP DATE: 23-FEB-2019	ALLOY: 7075	CLAD: BARE	TEMPER: T7351
PRODUCT DESCRIPTION: KaiserSelect Plate	WEIGHT SHIPPED: 7160 LB (3247.75 KG)	QUANTITY: 4 PCS EST.	TRUCK B/L #: 2079240	GAUGE: 2.5000 IN (63.5000 MM)
DIAMETER/WIDTH: 48.500 IN (1231.9 MM)	LENGTH: 144.500 IN (3670.3 MM)			

MHU 2302241: LOT 300352B2: 1 pieces;
MHU 2302242: LOT 300352B2: 1 pieces;
MHU 2302243: LOT 300352B2: 1 pieces;
MHU 2302244: LOT 300352B2: 1 pieces;

Certified Specifications

AMS 4078/RevK
ASTM B 209/Rev14
BSS 7055/RevB
DPS 4.713/RevAK
GSS16100/RevG/Amd1
PS 21211/RevP

AMS-QQ-A-250/12/RevA
ASTM B 594/Rev13
CMMP 025/RevV
EAC MS1011/RevE
MMS 159/RevT

AMS-STD-2154/RevC
BAC 5439/RevJ
CSTI 006/RevE
GAMPS 9101/RevB/AmdSCN1
PPS 20.04/Rev7

Test Code: 4297

Lot: 300352B2 Cast 756

Drop 53

Test Results

Ingot 2

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	70.9 : 71.6 (489 : 494)	59.4 : 60.5 (410 : 417)	12.6 : 12.8

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	41.0 Min	41.5 Max
(MS/M) :	23.8 Min	24.1 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.07	0.19	1.6	0.03	2.4	0.20	5.7	0.03	0.01	0.01	TOT 0.04





CERTIFIED TEST REPORT

Trentwood Works

PO Box 15108, Spokane Valley WA 99215-5108

15000 E Euclid, Spokane Valley WA 99216

Phone: (800) 367-2586

Serial Number

4552523

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS

AMC CA-15413B R 9

7055

TEST NOTES

Metal represented by this test report was 100% Type I (immersion) ultrasonically tested from one side with 3mm dead zones top and bottom and meets the Class A and Class B requirements of all specifications referenced on this test report. No surface marking of sonic indications is performed.

CERTIFICATION

Kaiser Aluminum, Trentwood Works, is ISO 9001, AS9100, and ISO 14001 certified, and hereby certifies that all material shipped under this order:

- * has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein.
 - * All test equipment and measuring devices are calibrated and certified in accordance applicable specifications. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements. Reported elongation values have been measured as elongation at fracture.
 - * was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
 - * has been thermally processed in compliance with AMS 2772, where applicable.
 - * is mercury free, within the limits of detection of ASTM E1215 (< 1ppm).
 - * is in compliance with RoHS 2, European Union Directive 2011/65/EU.
 - * is in compliance with European Chemical Agency, ECHA, REACH regulations, (EC) No 1907/2006, and Kaiser regularly monitors these regulations for updates.
 - * is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
 - * is free of weld repair.
 - * meets the reporting requirements of EN10204, Type 3.1.
- Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

Michael Peske, PT Lab Process Engineer



MATERIAL RECEIPT INSPECTION FORM

MATERIAL: N6101-005
DATE: NOV 01 2019

PO / BATCH NO.: DA18044870 / 5228697

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 20 pcs
QUANTITY INSPECTED: 20 pcs
QUANTITY REJECTED: —

THICKNESS ORDERED: 2.5"
THICKNESS RECEIVED: 2.5"
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	☒ Y	☒ N	
CORRECT FINISH	☒ Y	☒ N	
CORROSION	☒ Y	☒ N	
CORRECT GRAIN DIRECTION	☒ Y	☒ N	
CORRECT MATERIAL PER M-DRAWING	☒ Y	☒ N	<u>AMS-00-4-250</u>
CORRECT THICKNESS	☒ Y	☒ N	
PHOTO REQUIRED	☒ Y	☒ N	
CORRECT REF # TO LINK CERT	☒ Y	☒ N	<u>HT: 300352B2</u>
CORRECT MATERIAL IDENTIFICATION	☒ Y	☒ N	
CORRECT M# ON THE MATERIAL	☒ Y	☒ N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	☒ Y	☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	☒ Y	☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: _____	DAS 81 9-80	SIGNED OFF BY: _____	
DATE: <u>NOV 01 2019</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in